FIG.1

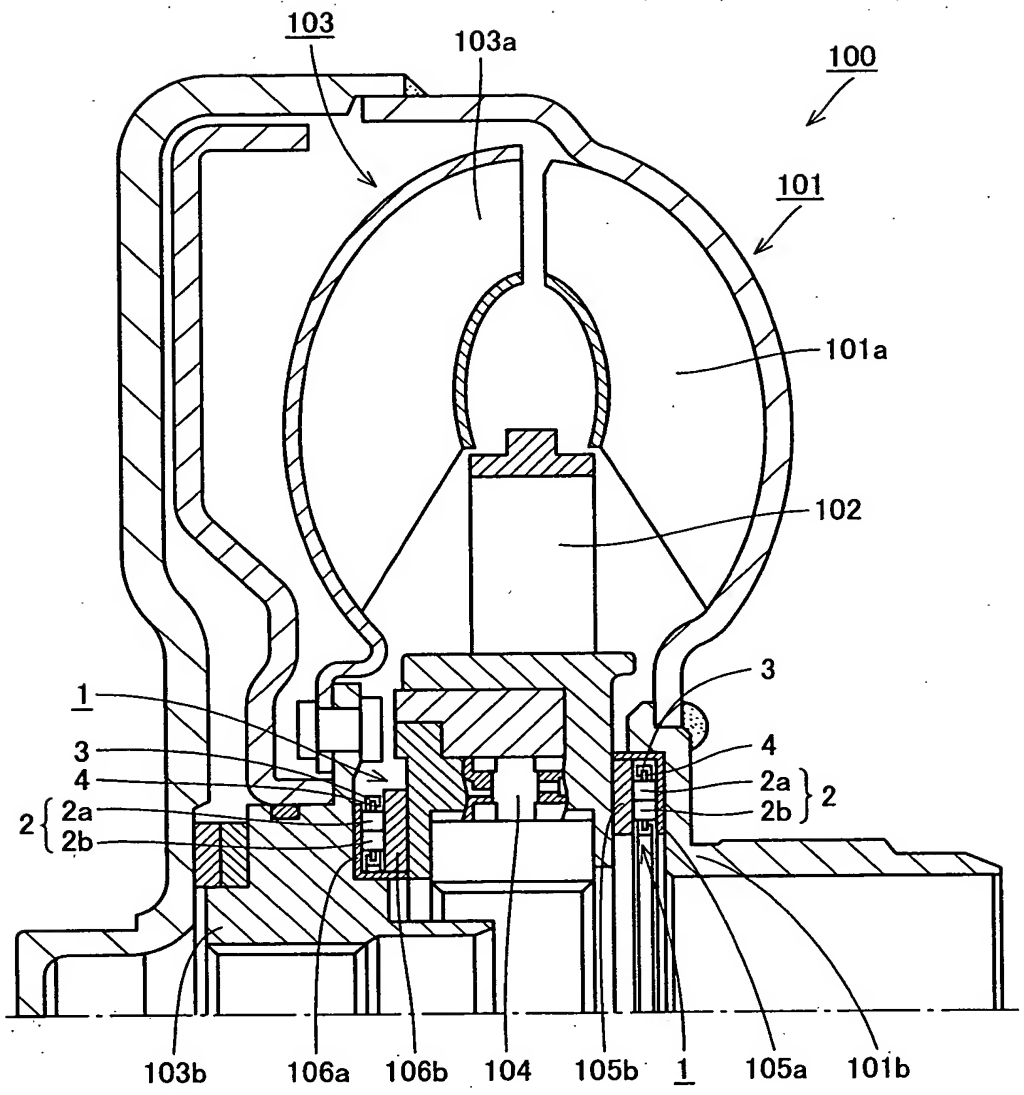
103
103a
100
101
101a
102
3
1
3
4
4
2a
2b
2
2
2a
2b
103b
106a
106b
104
105b
1
105a
101b

FIG.2A

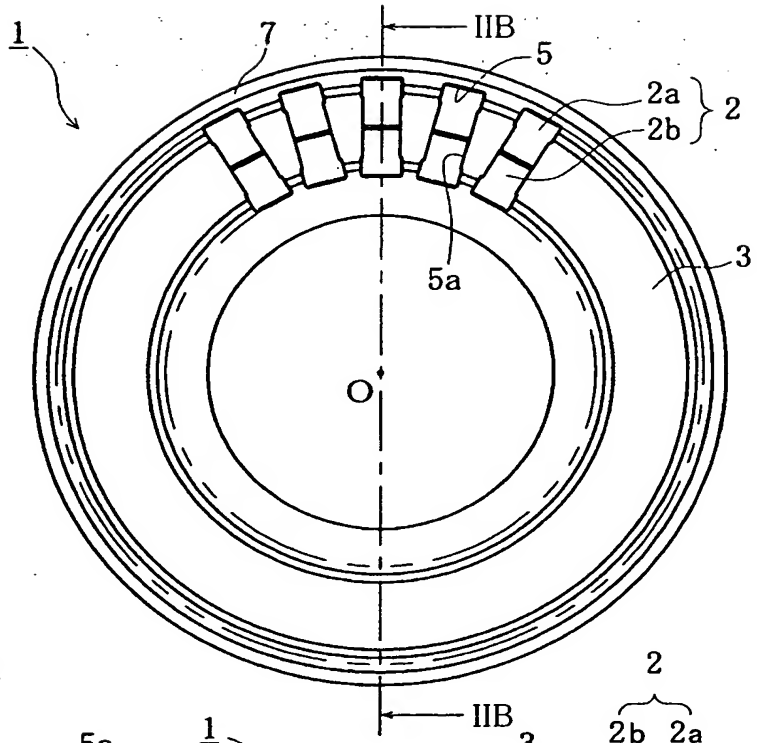

FIG.2B

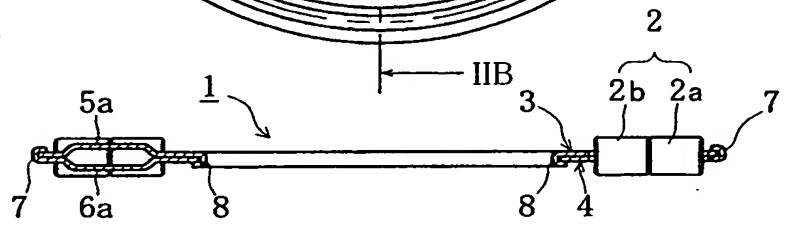

FIG.2C

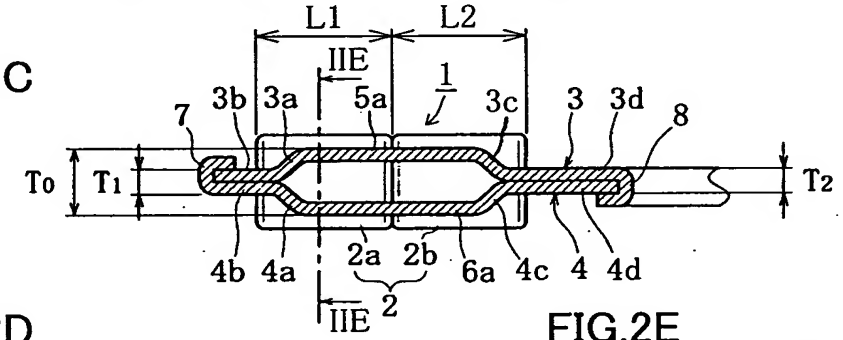

FIG.2D

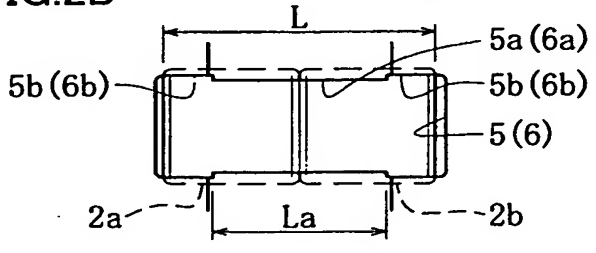

FIG.2E

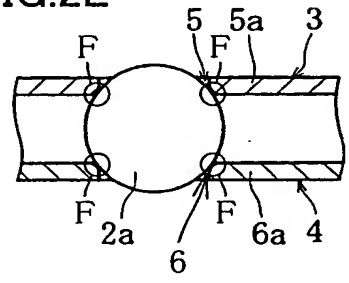

FIG.3

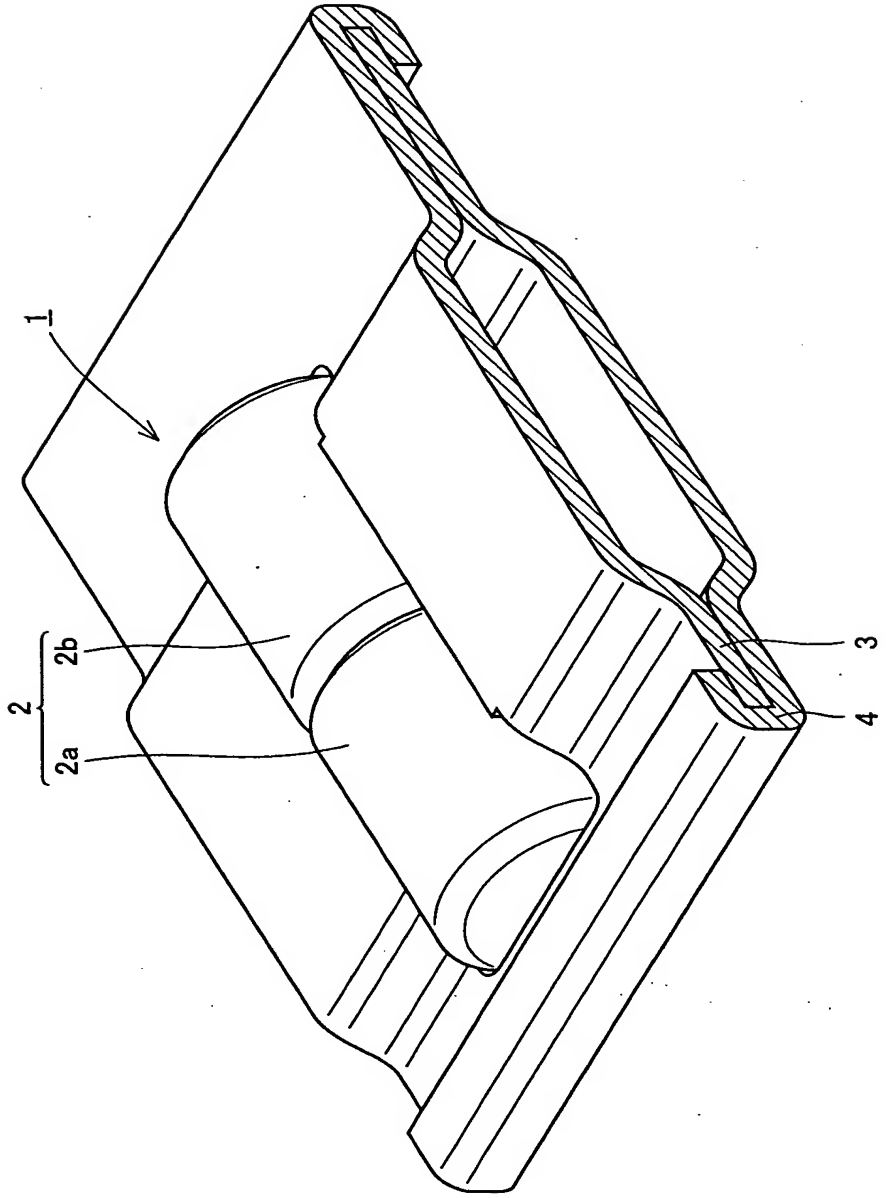

FIG.4

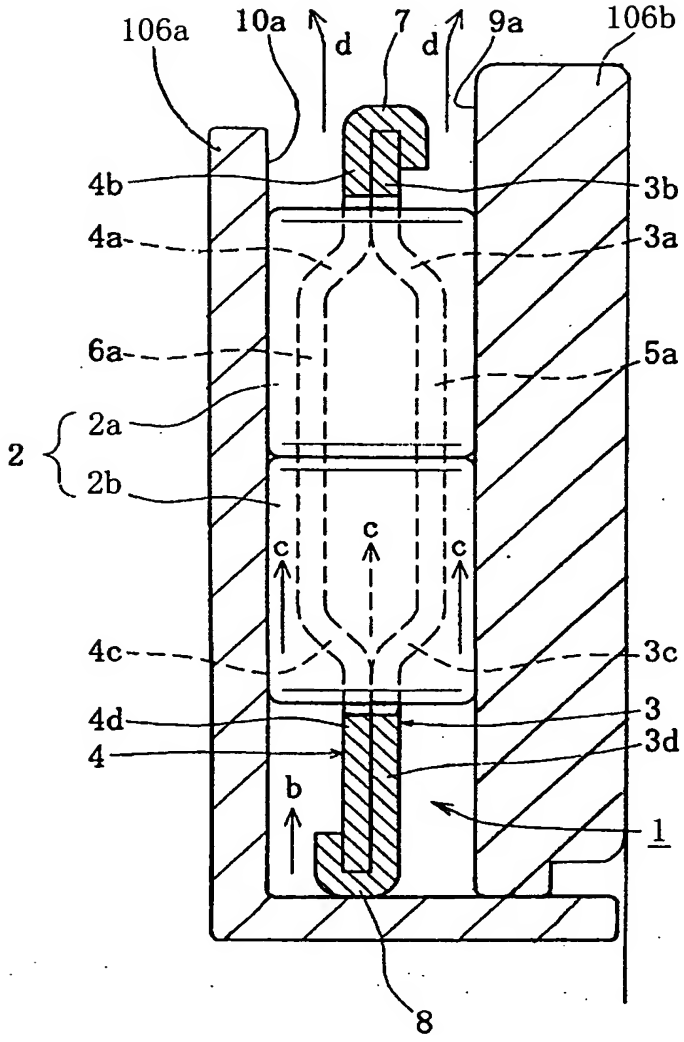

FIG.5

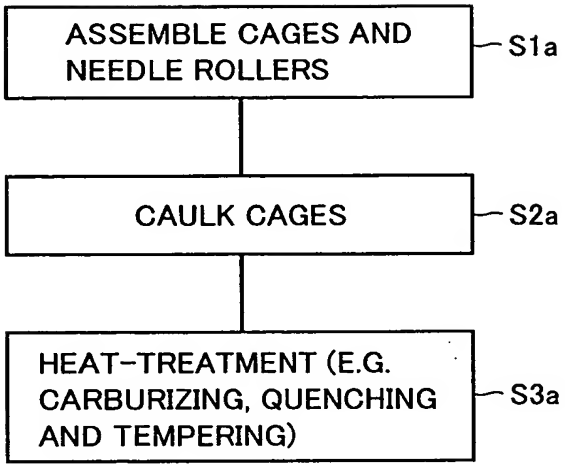
ASSEMBLE CAGES AND NEEDLE ROLLERS
S1a
CAULK CAGES
S2a
HEAT-TREATMENT (E.G. CARBURIZING, QUENCHING AND TEMPERING)
S3a

FIG.6

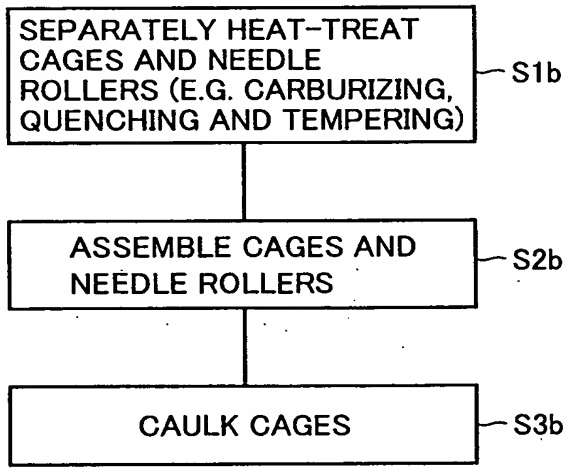
SEPARATELY HEAT-TREAT CAGES AND NEEDLE ROLLERS (E.G. CARBURIZING, QUENCHING AND TEMPERING)
S1b
ASSEMBLE CAGES AND NEEDLE ROLLERS
S2b
CAULK CAGES
S3b

FIG.7A

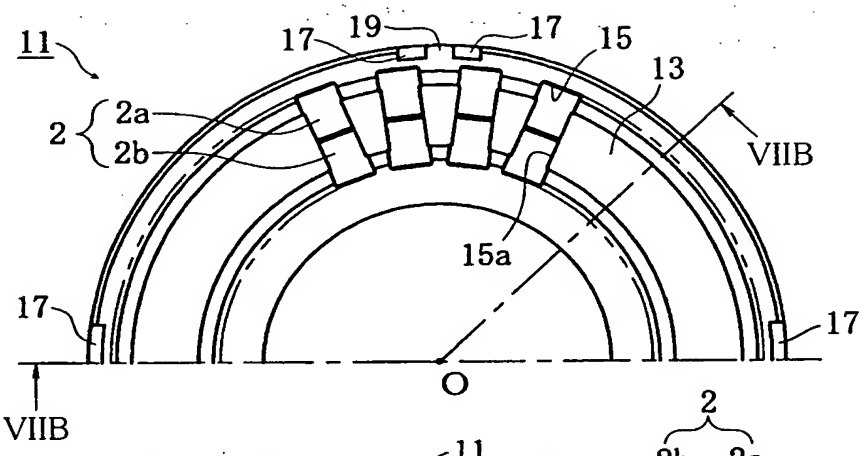

FIG.7B

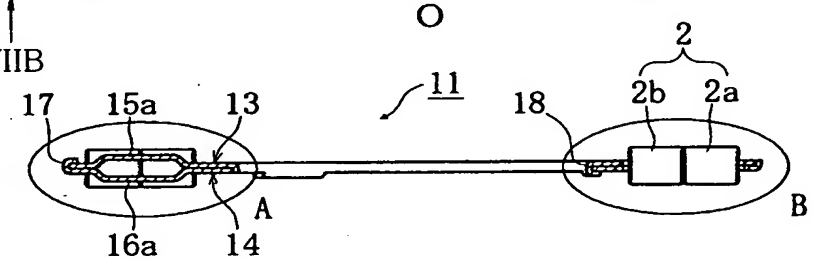

FIG.7C

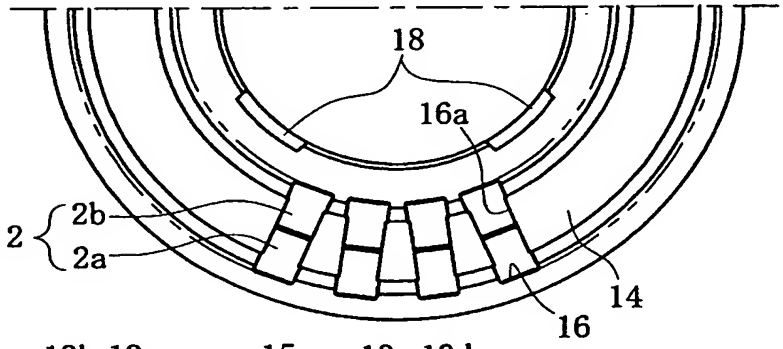

FIG.7D

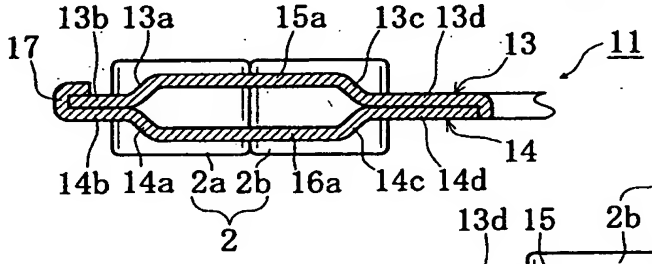

FIG.7E

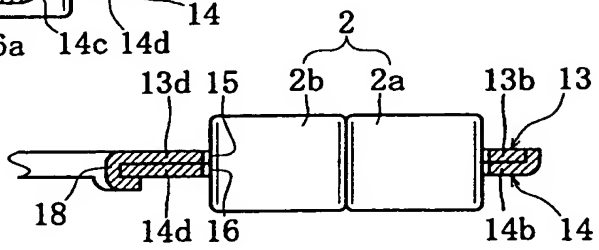

FIG.8A

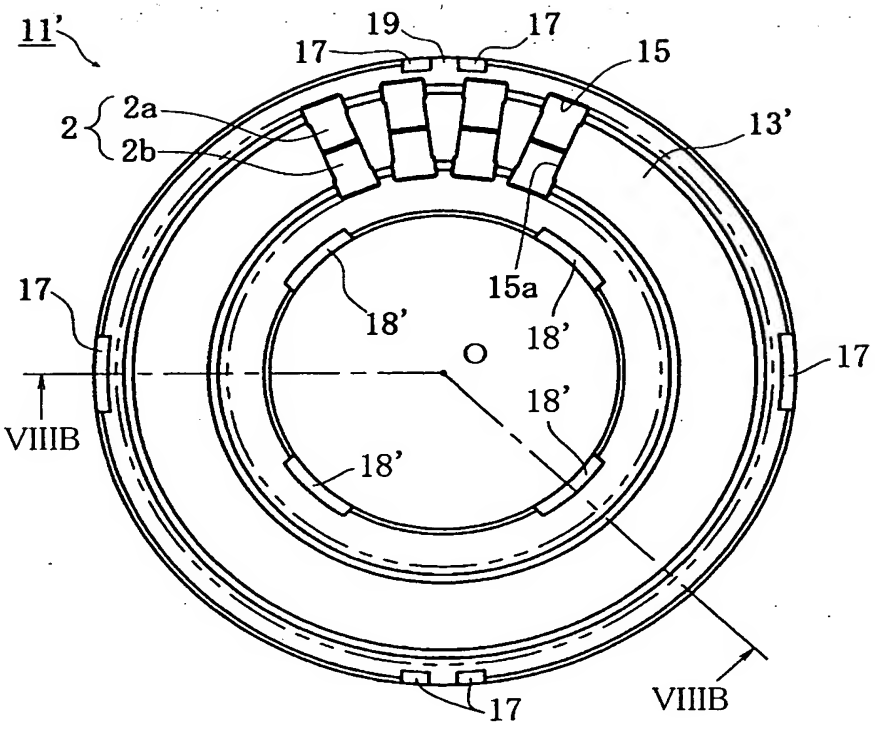

FIG.8B

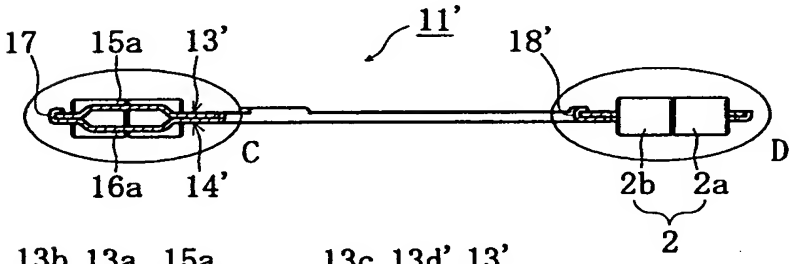

FIG.8C

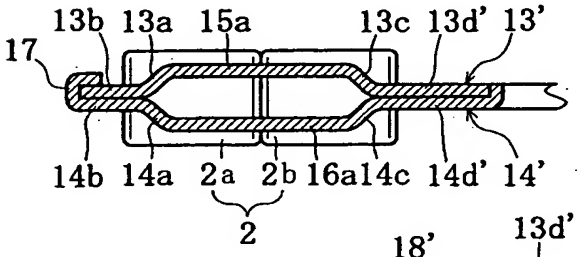

FIG.8D

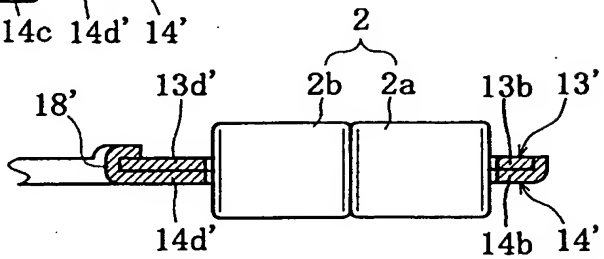

FIG.9A

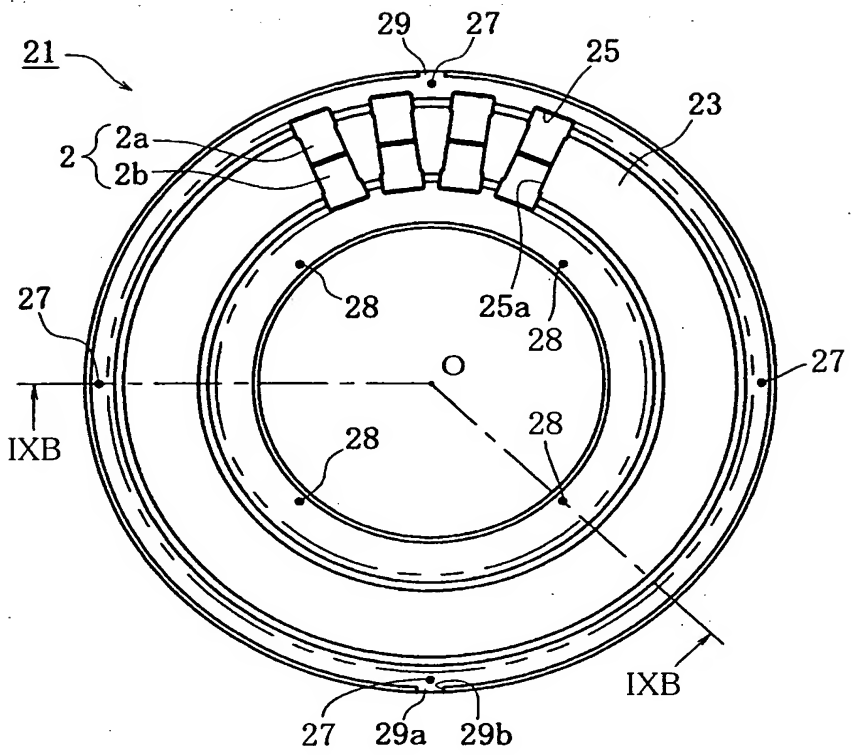

FIG.9B

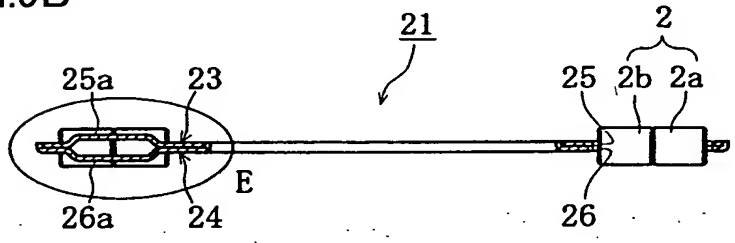

FIG.9C

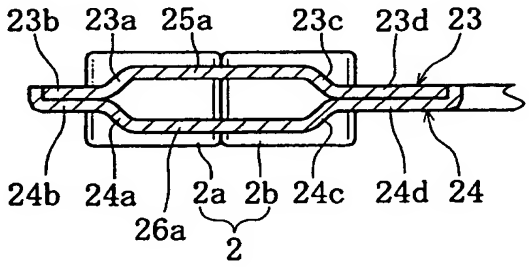

FIG.10

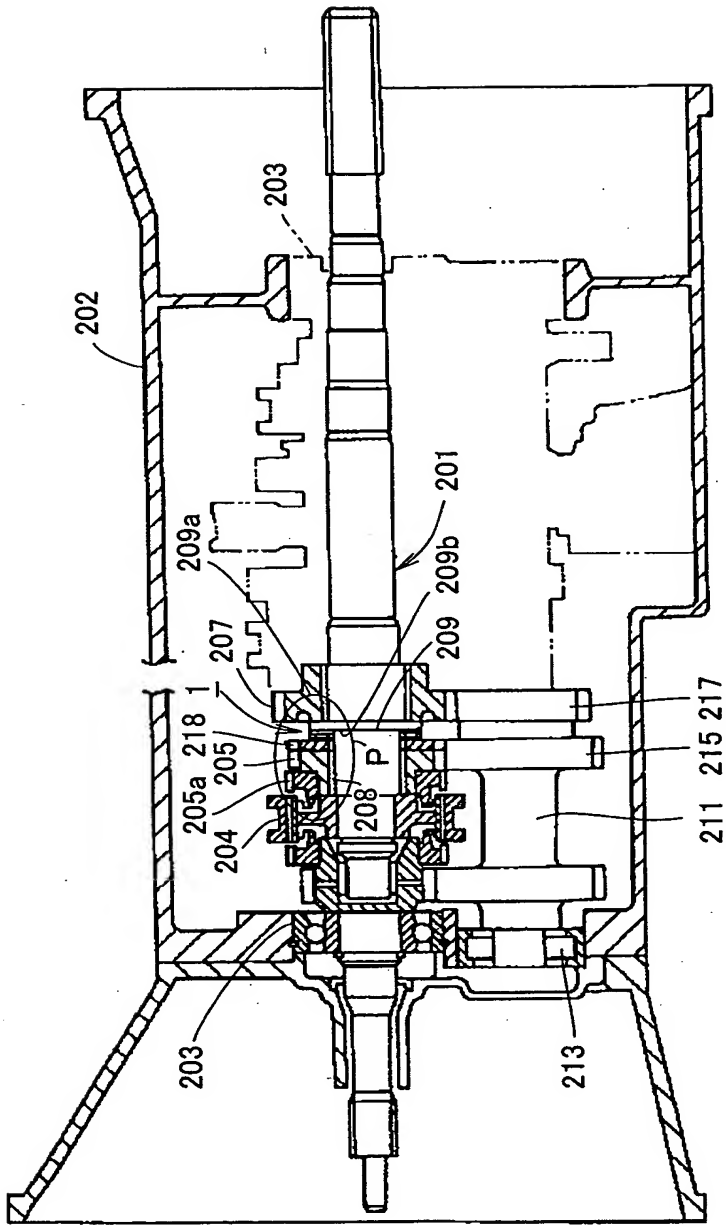
202
203
201
209a
209b
209
207
1
218
205
205a
204
208
P
217
215
211
213
203

FIG.11

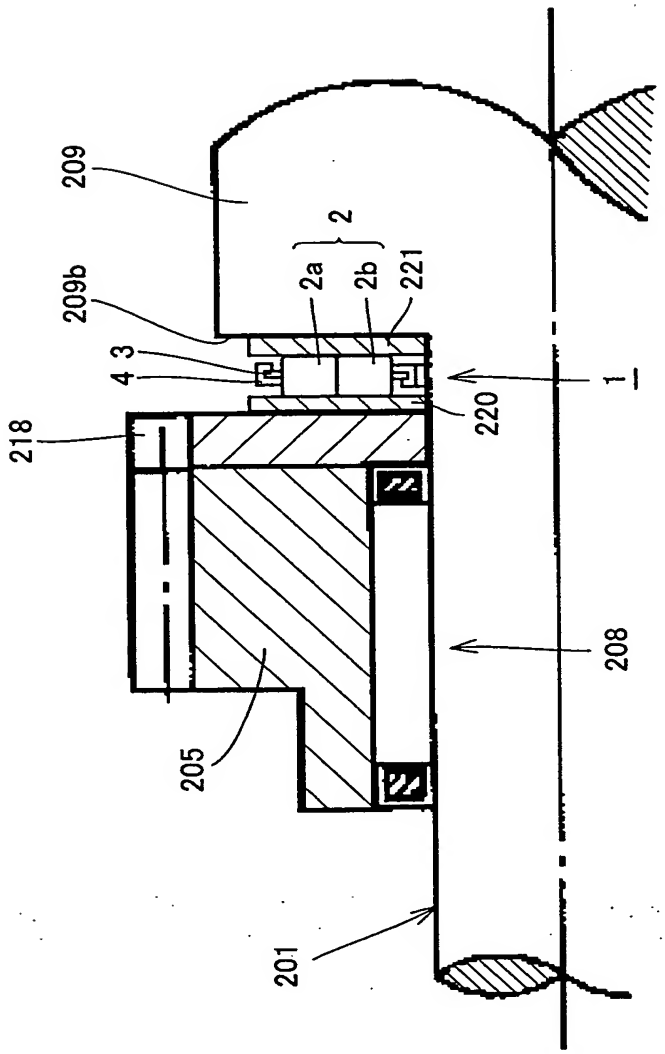

FIG.12A

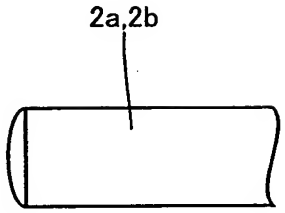

FIG.12B

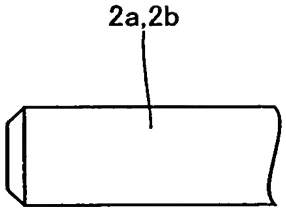

FIG.13

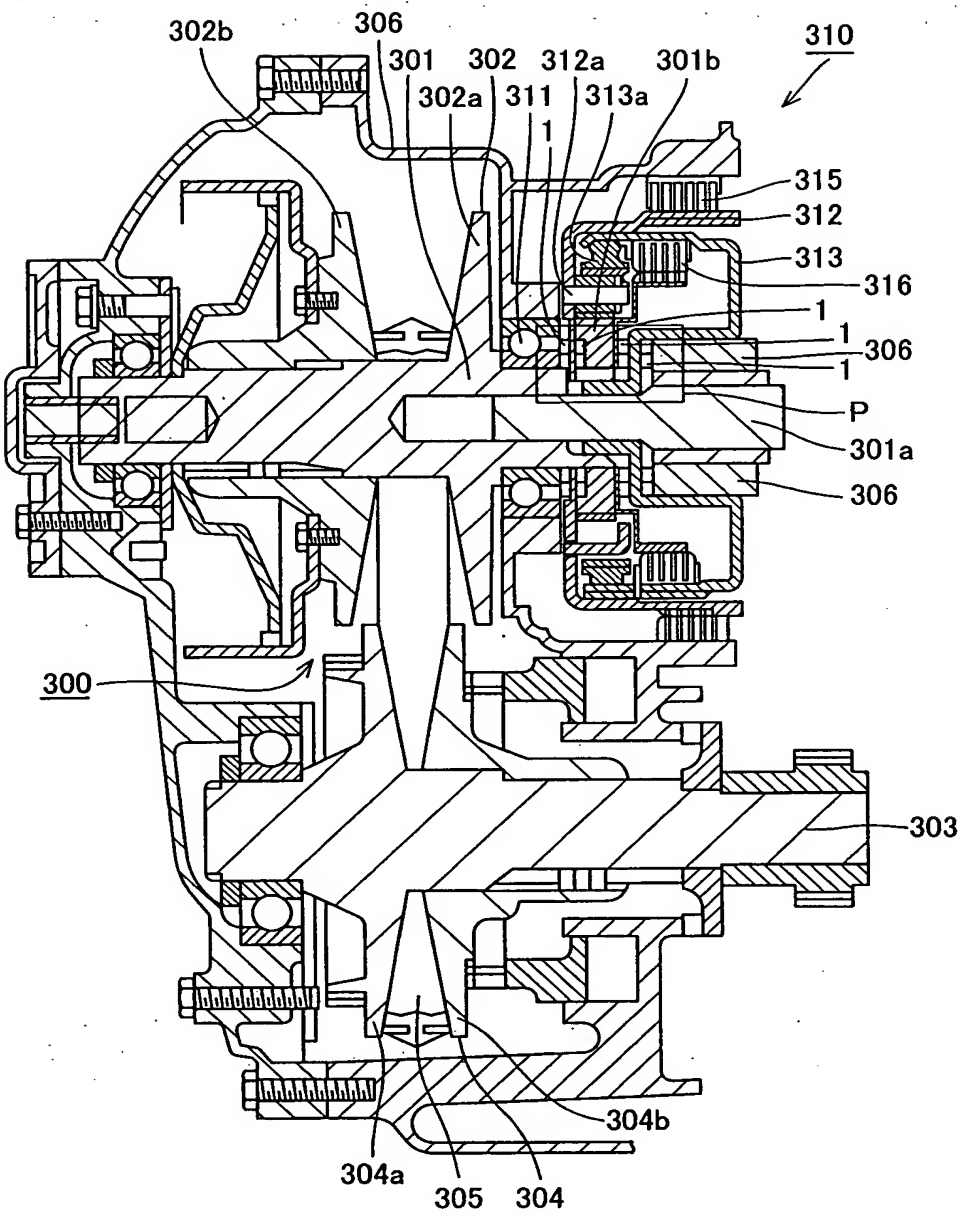
302b
306
301
302
312a
301b
310
302a
311
313a
1
315
312
313
316
1
1
306
1
P
301a
306
300
303
304b
304a
305
304

FIG.14

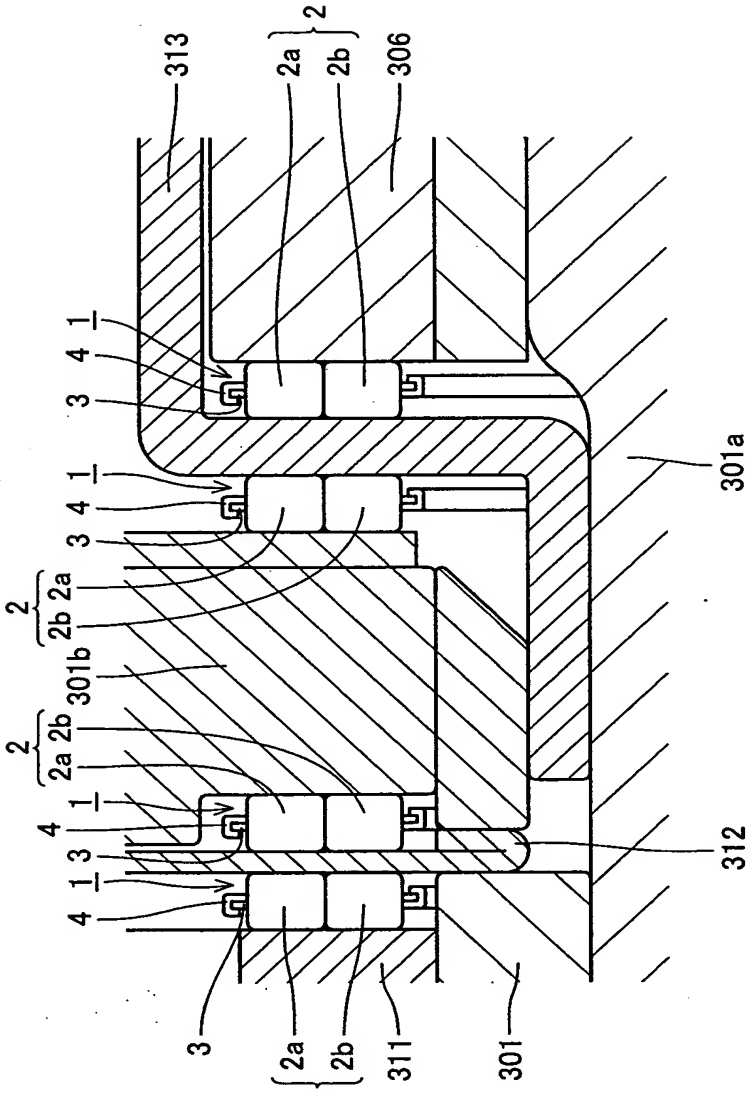
313
2
2a
2b
306
1
4
3
301a
2
2a
2b
301b
2
2a
2b
1
4
3
1
4
312
3
2
2a
2b
311
301

FIG.15

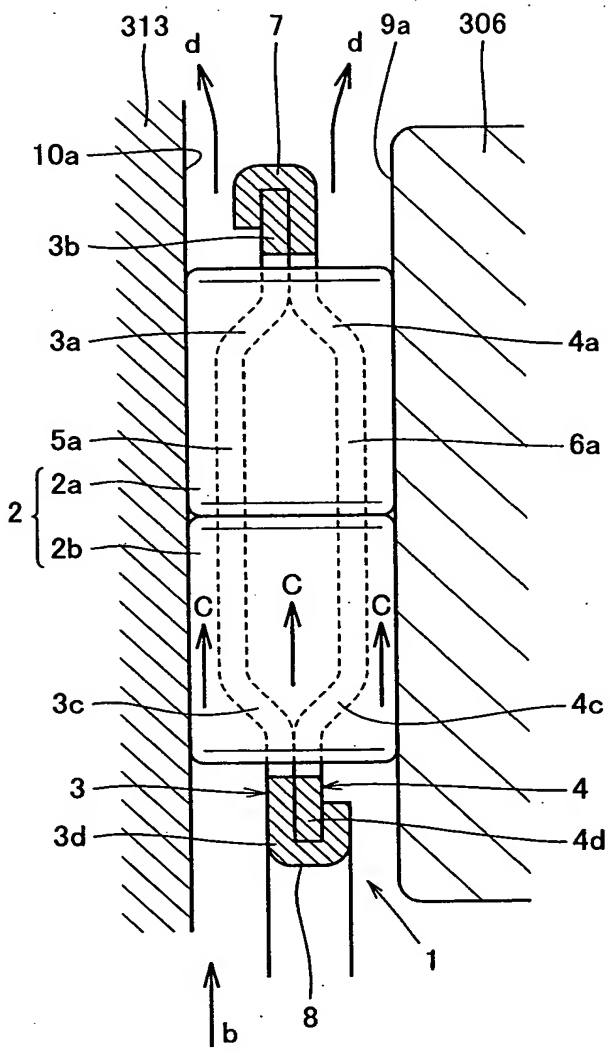

FIG.16A

TYPE 1

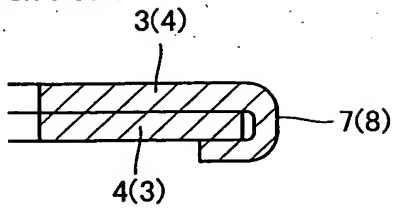

FIG.16B

TYPE 2

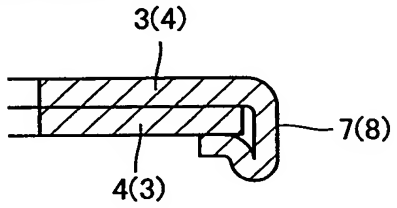

FIG.16C

TYPE 3

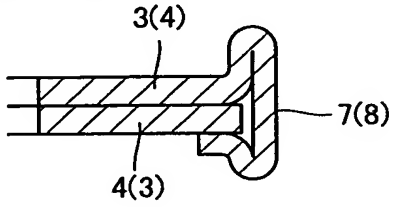

FIG.16D

TYPE 4

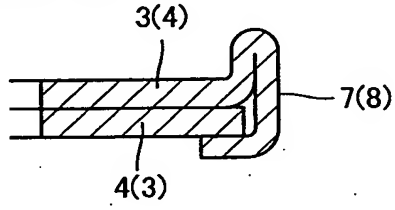

FIG.16E

TYPE 5

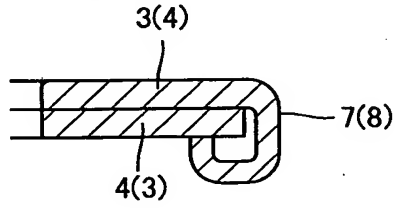

FIG.17A PRIOR ART

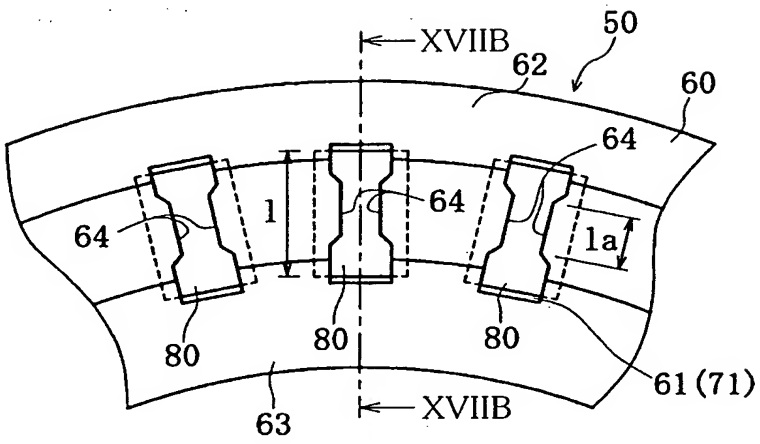

FIG.17B PRIOR ART

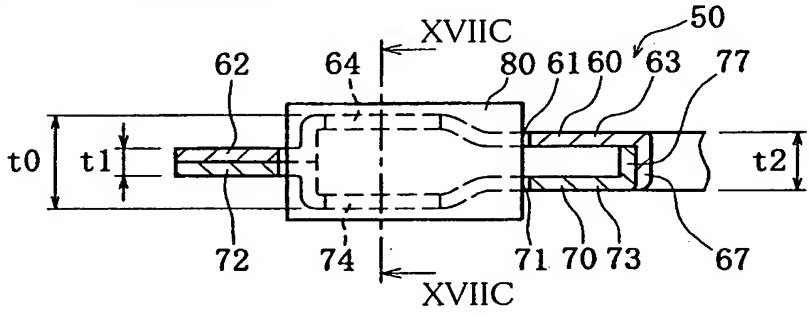

FIG.17C PRIOR ART